

Work Order ID 144212

April 07, 2016 1:54:00 PM

144212

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Item ID: D3348-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Clevis
 Start Date: 4/8/2016 Start Qty: 16.00 *16* Cust Item ID:
 Required Date: 4/15/2016 Req'd Qty: 16.00 *16* Customer:
 Reference:

Approvals: Process Plan: SH 20160325 Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3348	Rev B								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3348 Dwg Rev: B Prog Rev: B 2-
 Deburr if necessary

(24) 04/16/11

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(24) 04/16/11

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(24) DAS 38 288 APR 11 2016 P.T.O.

DQA:

Date: 16.05.10



QA Closed:

Date: 16/04/27

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: 144212		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. D3348-1		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☒	Engineering ☐		
NCR No. 16-5739		Scrap ☒		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date: 16-04-11		Step #: 100		QTY Effective: 24			MRB (QSI042) Approval		
Description Work Order Deviation		Disposition			DAS 9 9-89 16-04-12				
Operator took wrong material too thick		Scrap / destroy			Completed By				
R.C. Operator		recut B144212			16/04/13				
					Lead hand / Supervisor Approval Verification				
					DAS 38 9-89 APR 12 2016				
					QC / QA Coordinator Approval				
					APR 11 2016				
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☒	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☒				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☒	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER: wrong materials							

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Packaging	Identify as per dwg & Stock Location: <i>WA004</i>	0.00							
Packaging	Memo *****STOCK IN-BASKET CELL***** LOCATION: WA004	0.00							
170 *170* QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

24 *11* *16-4-13*

MCS *APR 13 2016*

MCS APR 13 2016

Picklist Print

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Work Order ID: 144212

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Parent Item: D3348-1

D3348-1

Parent Item Name: Clevis

Start Date: 4/8/2016

Required Date: 4/15/2016

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP: A05.02.09New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S12GA		Purchased	No			100	sf	24.4000	0.0182	0.306526			
M1010S12GA									**			<u>02/16/04/11</u>	
1010/102 mild steel sheet 12ga													

Location

Loc Qty

Loc Code

MAT019

24.4

110933

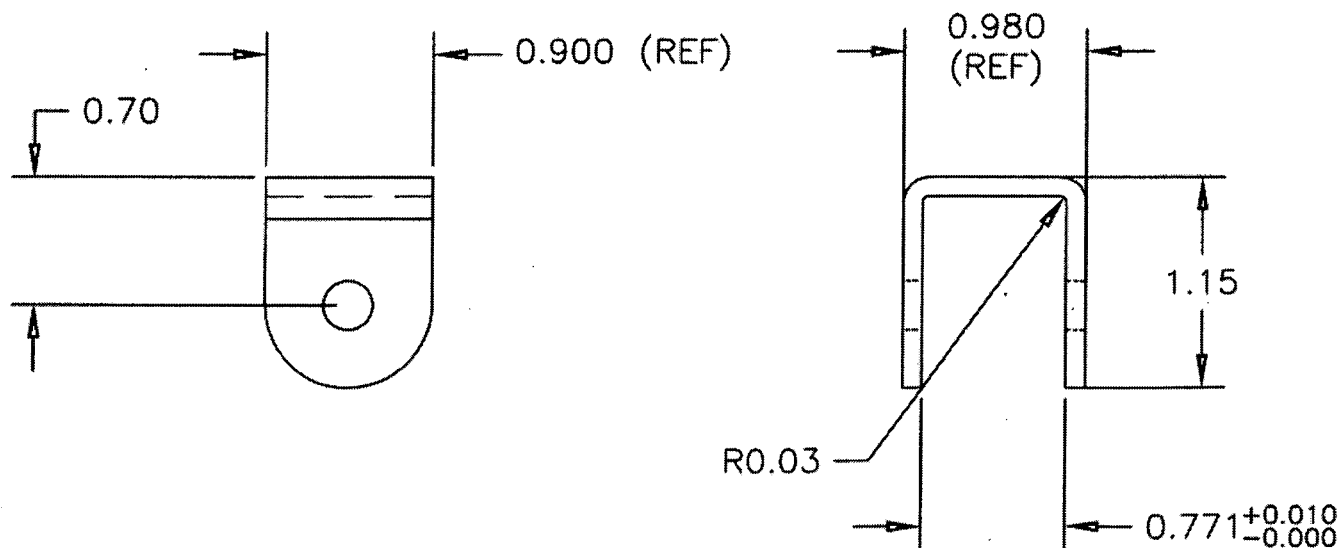
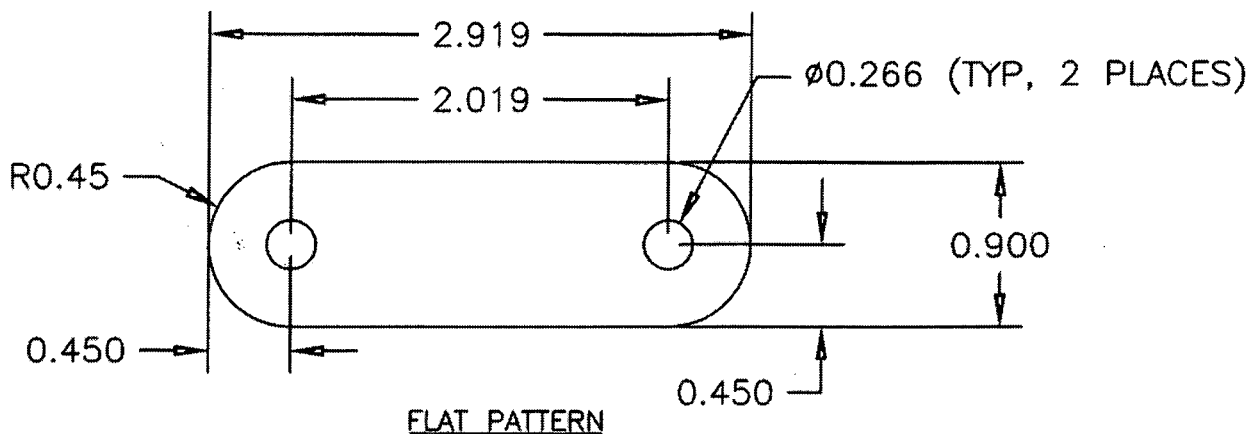
24.4

6



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3348	REV. B SHEET 1 OF 1
DATE 05.03.04		TITLE CLEVIS	SCALE 1:1
A	04.11.11	NEW ISSUE	
B	05.03.04	INSIDE RADIUS WAS R0.13, NOW R0.03	

RELEASED
05.03.05



BENDING DETAIL

D3348-1 CLEVIS

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR
CSA G40-21,38W/44W/50W/60W/70W SERIES STEEL 12 GAUGE (0.105 THICK)
(REF DART SPEC. M1010-S12GA)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

20160407

SA 144212

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